

# Work Order ID 63320

Wednesday, October 27, 2010 3:01:10 PM

Page 1

Item ID: D2947

Accept

Setup Start

Revision ID:

Stop

Item Name: Clamp

Start Date: 10/27/2010 Start Qty: 100.00

Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 100.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2947

Rev A1

100

0.00



Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 12825 ☐ E-mail or Ship DXF file to vendor ☐ Laser cut flat pattern as per Dwg D2947 ☐ Possible supplier: GFI ☐ Material release note is required.

CZ 10/10/28 (100)

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure material certification is attached

C 10/11/11 (100)

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

80w/11

contd  
(100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63320**

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

1- Deburr any rough edges

140



Small Fab

Small Fab

0.00

Memo

0.00

TUMBLE

150



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

AS PER QSP019

Quality Control

RB 10-11-18

8/10/11/18

count  
7140

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: 457

0.00



Packaging

Memo

0.00

Packaging

10/11/10 SP (100)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/10 SP

10-11-10 (100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, October 27, 2010 3:01:14 PM

Page 1

Work Order ID: 63320



Parent Item: D2947



Parent Item Name: Clamp


Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP: A□00.01.14□New issue□EC□  
IPP Rev:B No longer made in house 07-06-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2947B  Clamp		Purchased	No			100	Each	0.0000	1	105.2632		10/11/11	(100)

~~10-11-11~~  
(100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries



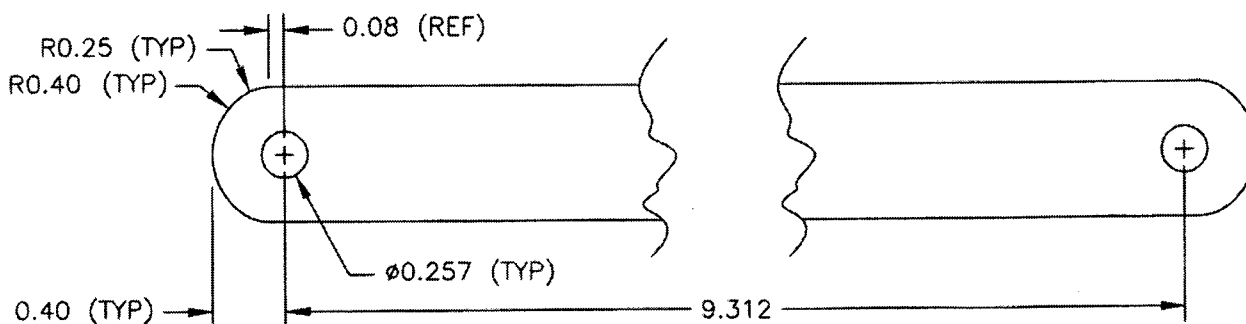
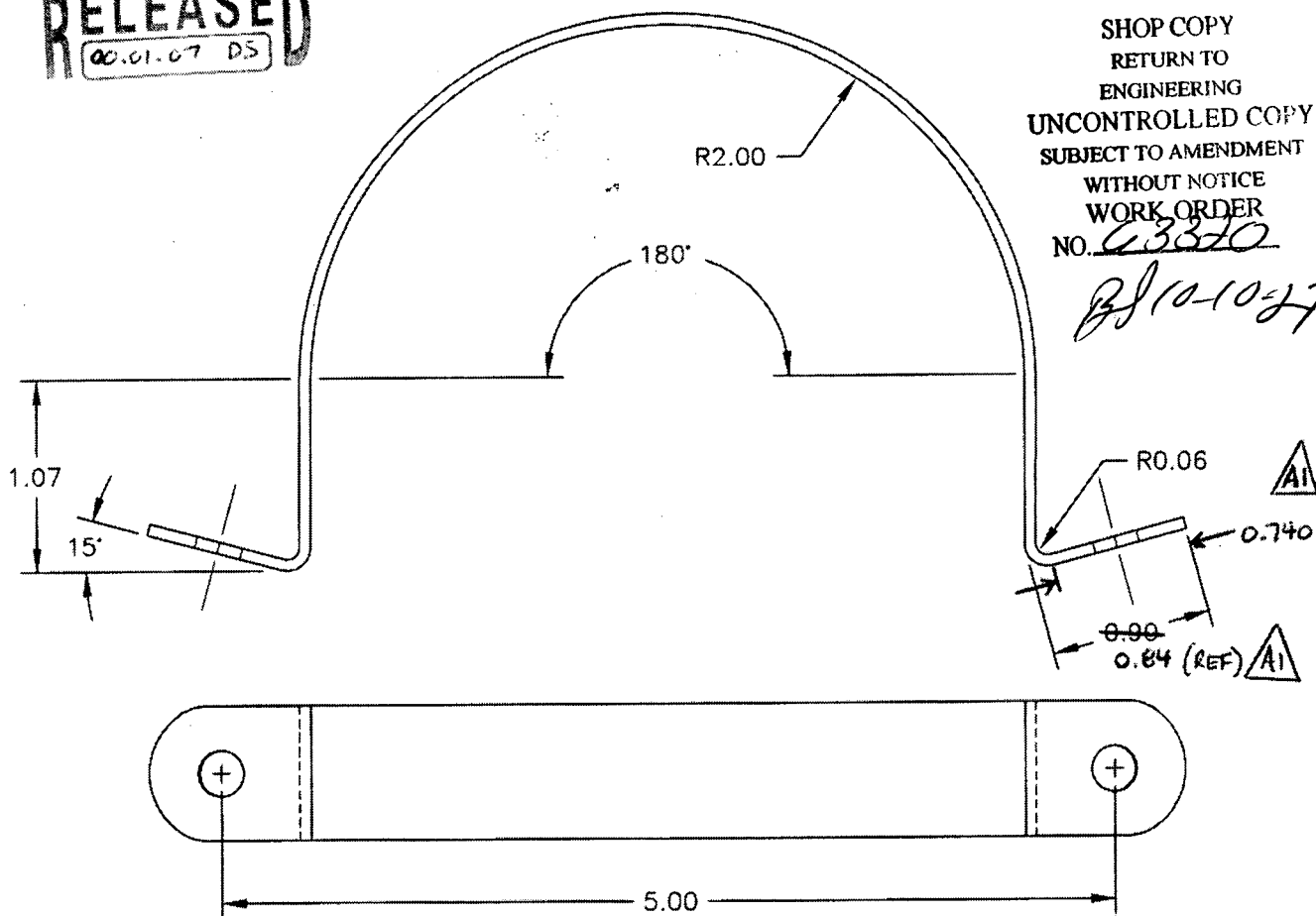


DESIGN <i>[Signature]</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2947	REV. A SHEET 1 OF 1
DATE 00.01.06		TITLE CLAMP	SCALE 1:1
A	00.01.06	NEW ISSUE	

RELEASED  
00.01.07 DS

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *63370*

*BJ10-1027*



D2947 FLAT PATTERN

MATERIAL: AISI 304/316 SS 0.063 THICK x 0.75 WIDE  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

*CP*  
01.09.07 Add 0.740 dimension; 0.84 LWS 0.90

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# SPECIFICATION CONTROL DRAWING

PURCHASE MATERIAL: AISI 304/316 SS SHEET  
ANNEALED  
2B FINISH

SPECIFICATION: MIL-S-5059  
OR AMS 5513 (304)  
OR AMS 5524 (316)  
OR ASTM A240  
OR ASME SA240

PART NUMBER: M304S TT GA  
GA

WHERE "TT" = GAUGE THICKNESS

EG. 16 GAUGE SS SHEET = M304S16GA

GAUGE THICKNESS REFERENCE:

GAUGE	NOM. THICK. (IN)	THICKNESS RANGE (IN)
26	0.01875	0.0178 - 0.019
25	0.021875	0.0199 - 0.023
24	0.025	0.024 - 0.026
23	0.028125	0.027 - 0.029
22	0.03125	0.030 - 0.032
21	0.034375	0.033 - 0.035
20	0.0375	0.036 - 0.040
19	0.04375	0.041 - 0.046
18	0.050	0.047 - 0.052
17	0.05625	0.053 - 0.058
16	0.0625	0.059 - 0.065
15	0.0703125	0.066 - 0.072
14	0.078125	0.073 - 0.083
13	0.09375	0.084 - 0.098
12	0.109375	0.099 - 0.114
11	0.125	0.115 - 0.130
10	0.140625	0.131 - 0.145
9	0.15625	0.146 - 0.160
8	0.171875	0.161 - 0.176

REFERENCE ONLY

RELEASED  
09/06/23 MP

B	REFORMAT DWG, ADD ASTM/ASME SPECS (ZN D8-1), ADD GAUGE REF (C8-1), REF PAR 08-020A	CP	09.06.01
A	NEW ISSUE	DS	01.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.01		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. M304S	REV. B
TITLE 304/316 SS SHEET	SHEET 1 OF 1
SCALE NTS	

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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO12825

Purchase Order Date 10/28/10

PO Print Date 10/28/10

Page Number 1 of 1

Order From :

VC-GFI001

GFI  
180 AVENUE LABROSSE  
POINTE CLAIRE, QC H9R 1A1  
CA

Contact Name

Vendor Phone 514 630 4877

Vendor Fax 514 630 4849

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAKED**  
e-mail Pedro

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2947B	Clamp	11/16/10 Yes	100.00 Each	Purolator ground	\$9.6500	\$965.00

Special Inst: AS PER DWG D2947 REV. A  
B63320

PO Total:

\$965.00

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

W CL

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 1

Change Date: 10/28/10



180 AVENUE LABROSSE  
POINTE-CLAIRE, QC, CANADA H9R 1A1  
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



# BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON / SHIPPING MEMO NO.	PAGE
JR - DY	MO - MO	AN - YR		
09	11	10	0449713	1/1



VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

CODE DE CLIENT / CUSTOMER CODE	N° DE CONTRAT / JOB NO	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO	EXPÉDIÉ PAR / SHIP VIA
DART GFI-0299	0222336	PO12825	

QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO	DESCRIPTION
---------------------	-----------------------	-------------

100 D2947B

CLAMP

CERTIFICATE OF CONFORMANCE REQ

*8*  
*colu / y*

MFG. JOB# 10222336-001 QTY 100

*04*



EXPÉDITEUR / SHIPPER

N° DE BON DE LIVRAISON / SHIPPING MEMO NO



REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.  
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

# CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. <u>14</u>		OUR JOB NO. <u>J0222336</u>		SHIPPING MEMO <u>0449713</u>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME
<u>-</u>	<u>100 PCS</u>	<u>PO12825</u>	<u>D2947B</u>	<u>A</u>	<u>CLAMP</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.	
<u>SST 304</u>		<u>TW METALS / NORTH AMERICAN</u>		<u>H/N# 4WN7</u>	
PROCESS			PROCESSOR	RELEASE NOTE #	
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>		<u>GFI</u>	<u>N/A</u>	
2	<u>REF. GFI MANUFACTURING JOB NUMBER J0222336-001 (100 PCS)</u>				
3					
4					
5					
6					
7					
8					
9					

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 10 NOVEMBER 2010

G.F.I. Q.C. REP. Dartan Howard



**DP12-001 REV 0 Bombardier Certificate of Compliance  
TW Metals District Procedure**

Revision: 0

Revision Date: 04-03-00

Superseding: Initial

Page: 1 of 1

**CERTIFICATE OF COMPLIANCE****FRAUD AND FALSIFICATION STATEMENT**

The recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law. Title 18 chapter 47.

**CERTIFICATE OF COMPLIANCE**

This certificate of compliance certifies that the material supplied on the purchase order number below complies in all respects with the material description and procurement specifications.

**MERCURY FREE STATEMENT**

We certify that mercury, radium, or alpha bearing instruments and / or equipment which might cause contamination have not been used in the manufacture, fabrication, assembly or testing of any material supplied by TW Metals Inc. Switches, glass thermometers, standard cell and other items containing the above elements may be used, but they will be located so as not to constitute a contamination hazard.

CUSTOMER NAME: GFI, Inc  
PURCHASE ORDER No. 0076369  
ITEM No. 0001 SHIPPER INVOICE No. 03256240  
MATERIAL: 304- S/S Sheet SPECIFICATION: -  
MANUFACTURING MILL: North American Stainless  
SIZE: 0625 HEAT / LOT No. 4WN7  
PART No. TS06348X96A4 QUANTITY: 2 pcs  
TEST DEPARTMENT CLERK Janice Clark

AUTHORITY

Joe Schab  
Director of Quality Assurance

S  
6/14/11



# METALLURGICAL TEST REPORT

6870 Highway 42 East  
Ghent, KY 41045-9615  
(502) 347-6000

Certificate: 449204 01  
Customer: 0470 002  
Mail To:  
PENN STAINLESS PRODUCTS INC.  
P.O. BOX 9801  
190 KELLY ROAD  
QUAKERTOWN, PA 18951-9801

Ship To:  
PENN STAINLESS PRODUCTS INC.  
190 KELLY ROAD  
QUAKERTOWN, PA 18951-9801

Date: 2/02/2009 Page: 1

Steel: 304

Finish: 2B

Your Order: 140349

NAS Order: AN 0411727 01

Corrosion: ASTM A262/02a, 1808and-OK

## PRODUCT DESCRIPTION:

STAINLESS STEEL COIL, C.R. ANNEALED & PICKLED; UNS 30400  
ASTM A240/03, A480/03a, A666/03; ASME SA240/07, SA480/07, SA666/07  
CHEM ONLY ON FOLLOWING ASTM: A276/06a, A479/01, A484/06b, A312/07  
CHEM ONLY ON FOLLOWING ASME: SA312/07, SA479/07  
AMS 5513H DHR; MIL-6-5059D AMEND 3 (X CROWN MEAS)  
NACE MR0175/01, MR0103/07; Q35766D-A X MAG FERM  
MIN. SOLUTION ANNEAL TEMP 1900F, WATER QUENCHED

## REMARKS:

Mat'l is Free of Mercury Contamination. No weld repairs.  
EN 10204:2004 3.1; Q35763F Cond A; RoHS Compliant  
Material is Free of Radioactive Contamination  
NAS Steel Making Process: EAF, AOD, & Cont. Casting  
Product Mfg. by a Quality Mgt. Sys. in Conf. w/ISO 9001:2000  
Made & Manufactured in the USA; Mat'l is DPAAS Compliant

Product ID #	Coil #	Thickness	Width	Weight	Length	Mark	Pieces
034WN7 A	034WN7 A	.0595	48.0600	29.060	COIL	2925.9	11

## CHEMICAL ANALYSIS

HEAT	CR	C	CO	CR	CU	MN	MO	N	NI	P
4WN7	US	.0500	.1825	18.3895	.5550	1.7575	.2970	.0670	8.1365	.0315

## MECHANICAL PROPERTIES

Product ID #	Coil #	UTS	2% YS	ELONG	Hard	Tail	A 262
034WN7 A	034WN7	FT	99.35	54.27	44.59	89.00	84.00
							OK

## TW METALS

TEST  
FEB 23 2009  
ACCEPTED BY  
ERIC HESS

NAS hereby certifies that the analysis on this certification is correct and the material meets the specifications stated.

QC ENGINEER

ERIC HESS

2/02/2009

Certificate of Mill Test Results  
Pg 1/1  
19Feb09  
SO QTN-866065-001

/ROSEMARY

PO/REL M49208225

PENN STAINLESS PRODUCTS, INC.

TW METALS INC  
SHEET 304 ANN STLS STL  
160A 2B FINISH X 48.0000" X 120.0000" L/S  
PART NO.